

CLAIMS

1. A process for the production of a pack filled with an active substance composition, comprising the steps of:

5 a) inserting a preformed pack-forming film comprising at least one integrally formed holding cup having an open side with the holding cup into a matching holder of a retaining mold;

10 b) introducing a quantity of uncompressed active substance composition into the holding cup before, during, or after process step a);

15 c) compressing the quantity of active substance composition in the holding cup to form a compact tablet in the holding cup itself by means of a compression mold using the holder of the retaining mold as a support;

20 d) on completion of process step c), removing the film with the active substance composition tablet in the holding cup from the retaining mold and delivering the film to further handling stages; and

25 e) before, during, or after process step d), closing the holding cup on its open side by applying a closure film or a cover.

2. The process of claim 1, wherein the film is continuously delivered and the holding cups are formed in the film by a roller assembly.

3. The process of claim 1, wherein the film is delivered at intervals and the holding cups are formed in the film by a flat thermoforming tool.

4. A process for the production of a pack filled with an active substance composition in tablet form, comprising the steps of:

30 a) placing a pack-forming film on a retaining mold comprising at least

one holder forming a holding cup;

b) introducing in a compression mold associated with the retaining mold and comprising a premix holder associated with the holder of the retaining mold, a quantity of uncompressed active substance composition and then performing the active substance composition in the premix holder before or during process step a);

5 c) closing the mold and pressing the preformed active substance composition from the premix holder onto the pack-forming film and, together with the film, into the holder of the retaining mold, shaping the film into a holding cup having an open side in the process, and compressing the preformed active substance composition to a compact tablet in the holder of the retaining mold using that holder as a support;

10 d) on completion of step c), removing the film with the active substance composition tablet in the holding cup from the retaining mold and delivering the film with the active substance composition tablet in the holding cup to further handling stages; and

15 e) before, during, or after process step d), closing the holding cup on its open side by applying a closure film or a cover.

20 5. The process of claim 4, wherein, in step c), the preformed active substance composition is forced out of the premix holder by a punch mounted for displacement in the compression mold.

25 6. The process of claim 4, wherein, in step c), the preformed active substance composition is forced out of the premix holder by compressed air.

30 7. The process of claim 5, wherein, in step c), the preformed active substance composition is forced out of the premix holder by compressed

air.

8. The process of claim 4, wherein the drawing of the pack-forming film into the holder in step c) is supported by air leaving the holder of the
5 retaining mold or by the suction of air from the holder of the retaining mold.

9. The process of claim 1, wherein the process steps are carried out on a continuous film by roller assemblies, co-circulating belt arrangements or intermittently co-circulating tools.

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10. The process of claim 4, wherein the process steps are carried out on a continuous film by roller assemblies, co-circulating belt arrangements or intermittently co-circulating tools.

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11. The process of claim 1, wherein the process steps are each carried out quasi-statically on a film section.

12. The process of claim 4, wherein the process steps are each carried
20 out quasi-statically on a film section.

13. The process of claim 1, wherein several holding cups are formed beside and/or behind one another in the film and are simultaneously filled with active substance composition.

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14. The process of claim 4, wherein several holding cups are formed beside and/or behind one another in the film and are simultaneously filled with active substance composition.

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15. The process of claim 1, wherein a plastic film is used as the pack-

forming film.

16. The process of claim 15, wherein the plastic film comprises polyethylene or polyvinyl chloride.

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17. The process of claim 4, wherein a plastic film is used as the pack-forming film.

18. The process of claim 16, wherein the plastic film comprises
10 polyethylene or polyvinyl chloride.

19. The process of claim 1, wherein a metal foil is used as the pack-forming film.

15 20. The process of claim 19, wherein the metal foil comprises aluminium.

21. The process of claim 4, wherein a metal foil is used as the pack-forming film.

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22. The process of claim 21, wherein the metal foil comprises aluminium.

23. The process of claim 1, wherein a metal foil is used as the closure
25 film.

24. The process of claim 23, wherein the metal foil comprises aluminium.

30 25. The process of claim 4, wherein a metal foil is used as the closure

film.

26. The process of claim 25, wherein the metal foil comprises aluminium.

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27. The process of claim 1, wherein a plastic film is used as the closure film.

10 28. The process of claim 27, wherein the plastic film comprises polyethylene or polyvinyl chloride.

29. The process of claim 4, wherein a plastic film is used as the closure film.

15 30. The process of claim 29, wherein the plastic film comprises polyethylene or polyvinyl chloride.

31. The process of claim 1, wherein the closure film or the cover are joined to the pack-forming film in childproof manner.

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32. The process of claim 4, wherein the closure film or the cover are joined to the pack-forming film in childproof manner.

25 33. The process of claim 1, wherein the film filled with tablets in the holding cups and provided with closure film or covers is cut into marketing units.

30 34. The process of claim 4, wherein the film filled with tablets in the holding cups and provided with closure film or covers is cut into marketing units.

35. The process of claim 33, wherein, to form a marketing unit, several packs are placed in a paperboard carrier with corresponding openings.

5 36. The process of claim 34, wherein, to form a marketing unit, several packs are placed in a paperboard carrier with corresponding openings.

37. The process of claim 1, wherein tablets of different active substance compositions are formed in holding cups in a marketing unit.

10 38. The process of claim 4, wherein tablets of different active substance compositions are formed in holding cups in a marketing unit.

15 39. The process of claim 1, wherein a two-layer film is used as the closure film and an additional body of an active substance composition is arranged between the layers of the closure film.

20 40. The process of claim 4, wherein a two-layer film is used as the closure film and an additional body of an active substance composition is arranged between the layers of the closure film.

25 41. A pack filled with an active substance composition in the form of a compact tablet, the pack comprising a pack-forming film provided with at least one integrally formed holding cup having an open side and a bottom and a closure film that closes or covers the holding cup, the tablet being accommodated in the holding cup, wherein an edge of the tablet at the bottom of the holding cup corresponds in its profile to the edge profile of the holding cup.

30 42. The pack of claim 41, wherein the tablet bears against an encircling

inner wall of the holding cup over virtually its entire circumference.

43. The pack of claim 41, wherein the edge of the tablet at the bottom of the holding cup has a different contour from an edge of the tablet facing the 5 open side of the holding cup.

44. The pack of claim 41, wherein the pack-forming film is a plastic film.

45. The pack of claim 44, wherein the plastic film comprises 10 polyethylene or polyvinyl chloride.

46. The pack of claim 41, wherein the pack-forming film is a metal foil.

47. The pack of claim 46, wherein metal foil comprises aluminium.

15 48. The pack of claim 41, wherein the closure film is a metal foil.

49. The pack of claim 48, wherein metal foil comprises aluminium.

20 50. The pack of claim 41, wherein the closure film is a plastic film.

51. The pack of claim 50, wherein the plastic film comprises polyethylene or polyvinyl chloride.

25 52. The pack of claim 41, wherein the closure film is a two-layer film between the layers of which an additional body of an active substance composition can be accommodated under protection.

30 53. A plurality of packs according to claim 41, placed in a paperboard carrier with corresponding openings and, with the carrier, forming a

marketing unit .

54. The pack of claim 41, wherein tablets of different active substance compositions are placed in holding cups in a marketing unit.

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55. The process of claim 1, wherein the active substance composition comprises a laundry detergent, a dishwasher detergent, a water-soluble washing or cleaning aid, or an adhesive.

10 56. The process of claim 4, wherein the active substance composition comprises a laundry detergent, a dishwasher detergent, a water-soluble washing or cleaning aid, or an adhesive.

15 57. The pack of claim 41, wherein the active substance composition comprises a laundry detergent, a dishwasher detergent, a water-soluble washing or cleaning aid, or an adhesive.